

Work Order ID 59300

Page 1

Monday, May 31, 2010 12:56:52 PM

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 5/31/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: 14Date: 10-5-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. 59300Double check by: 8/5

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

DJP 10/06/04120MMV 10/06/07DJP 10/06/08MMV 10/06/07120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59300

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Page 2

Item ID: D2572

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

STP 10/06/08
*mm 10/06/07**12 0*

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*ant 10/06/10**12 0*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BR 10-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, May 31, 2010 12:56:52 PM



Page 3

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Item Name: Saddle, Fwd In 205

Start Date: 5/31/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M114841

0.00

=> M 10/06/11 12 0

Memo

START TIME: 8:15 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:45 AM

Powder Coating

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 10 06 11 (12)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 23

0.00

Memo

0.00

C 10/6/11 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 59300

Monday, May 31, 2010 12:56:52 PM



Page 4

Item ID: D2572

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Item Name: Saddle, Fwd In 205

Start Date: 5/31/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/14/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14
ME
10-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 31, 2010 12:56:57 PM

Page 1

Work Order ID: 59300



Parent Item: D2572



Parent Item Name: Saddle, Fwd In 205

Start Date: 5/31/2010

Required Date: 6/14/2010

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	44.0000	1	8			



Saddle Billet



Location

Loc Qty

Loc Code

MAT46

44

46411

44

58676 —

DTT
10/06/04

9/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59302
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	5	6
A	0.438	0.443		.440	.440	.440	.440	.440	0.440
B	1.745	1.755		1.747	1.747	1.747	1.746	1.746	1.750
C	3.495	3.505		3.494	3.500	3.494	3.500	3.499	3.500
D	1.745	1.755		1.747	1.747	1.747	1.747	1.747	1.750
E	7.990	8.010		8.005	8.005	8.005	8.004	8.004	8.004
F	0.490	0.510		.505	.503	.493	.500	.501	0.501
G	0.257	0.262		.260	.260	.260	.260	.260	0.260
H	0.375	0.380		.377	.377	.377	.377	.377	0.377
I	0.490	0.510		.500	.500	.500	.500	.500	0.503
J	1.174	1.184		1.178	1.178	1.178	1.177	1.178	1.178
K	0.558	0.578		.570	.568	.568	.570	.570	.570
L	1.174	1.184		1.177	1.178	1.178	1.177	1.177	1.177
M	1.490	1.500		1.494	1.493	1.494	1.494	1.494	1.494
N	2.495	2.505		2.499	2.497	2.499	2.500	2.501	2.503
O	3.869	3.879		3.872	3.874	3.872	3.873	3.871	3.871
P	0.115	0.135		.131	.125	.125	.125	.125	.125
Q	0.115	0.135		.134	.135	.135	.135	.135	.135
R	0.240	0.260		.253	.251	.252	.252	.254	.253
S	0.115	0.135		.131	.135	.125	.126	.127	.127
T	0.178	0.198		.188	.188	.188	.188	.188	.188
U	2.940	2.980		2.956	2.958	2.957	2.958	2.958	2.957
V	0.230	0.250		.237	.240	.235	.236	.235	.238
W	0.115	0.135		.125	.125	.125	.125	.125	0.123
X	0.307	0.312		.310	.310	.311	.311	.312	0.312
Y	0.760	0.765		.762	.762	.760	.760	.760	0.762
Z	0.352	0.372		.363	.362	.358	.362	.361	0.360
AA	0.470	0.530		.500	.500	.500	.500	.500	.500
AB	0.615	0.635		.618	.616	.617	.619	.617	0.615
AC	0.053	0.073		.063	.063	.063	.063	.063	.063
AD	0.240	0.260		.250	.250	.250	.250	.250	.250
AE	1.375	1.395		1.387	1.388	1.387	1.386	1.386	1.387
AF	0.115	0.135		.135	.135	.135	.135	.135	.135
AG	0.240	0.280		.250	.260	.250	.260	.250	.250
AH	0.240	0.260		.253	.253	.249	.252	.250	.249
AI	2.000	2.020		2.005	2.000	2.005	2.004	2.004	2.005
AJ	0.023	0.043		.033	.033	.033	.033	.033	.033
Accept/Reject									

Measured by:	MW
Date:	10/06/05

Audited by:	CMF
Date:	10/06/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 59300
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

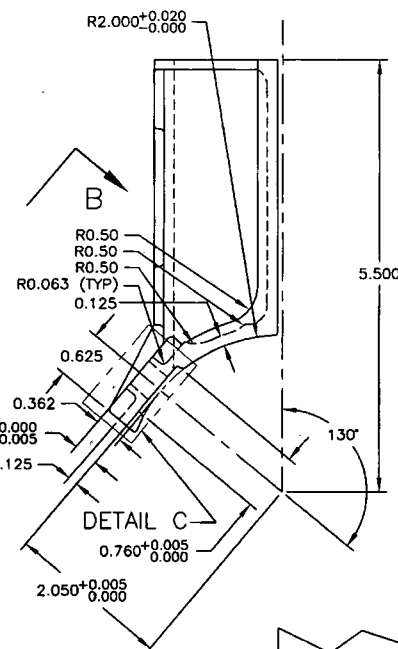
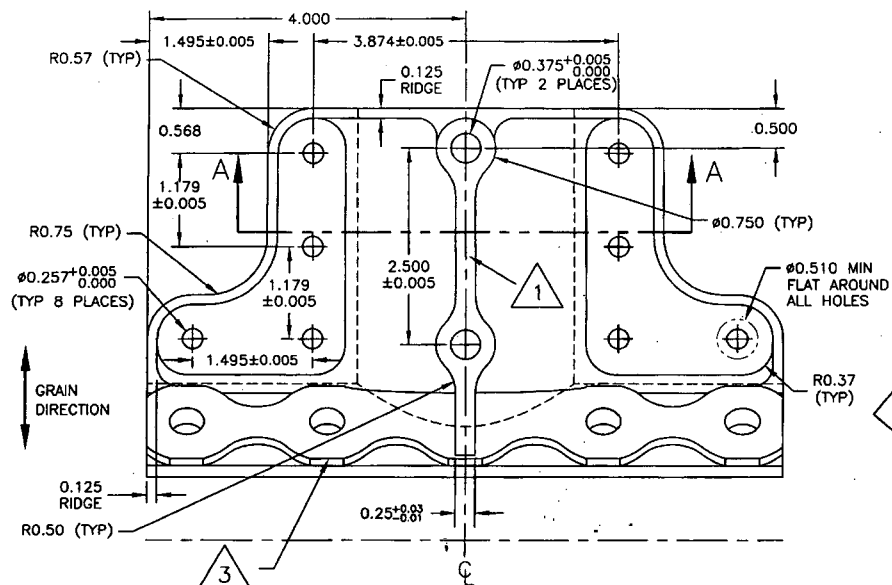
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#7	#8	#9	#10	#11	#12
A	0.438	0.443		0.441	0.441	0.441	0.441	0.441	0.441
B	1.745	1.755		1.750	1.750	1.750	1.750	1.750	1.750
C	3.495	3.505		3.500	3.500	3.500	3.500	3.500	3.500
D	1.745	1.755		1.750	1.750	1.750	1.750	1.750	1.750
E	7.990	8.010		8.004	8.004	8.004	8.004	8.004	8.004
F	0.490	0.510		0.499	0.498	0.497	0.492	0.492	0.490
G	0.257	0.262		0.260	0.260	0.260	0.260	0.260	0.260
H	0.375	0.380		0.377	0.377	0.377	0.377	0.377	0.377
I	0.490	0.510		0.500	0.500	0.504	0.503	0.503	0.501
J	1.174	1.184		1.179	1.179	1.179	1.179	1.179	1.179
K	0.558	0.578		0.569	0.568	0.570	0.570	0.570	0.568
L	1.174	1.184		1.179	1.179	1.179	1.179	1.179	1.179
M	1.490	1.500		1.493	1.495	1.495	1.495	1.495	1.495
N	2.495	2.505		2.499	2.500	2.500	2.500	2.500	2.500
O	3.869	3.879		3.871	3.874	3.874	3.874	3.874	3.874
P	0.115	0.135		0.125	0.125	0.125	0.125	0.124	0.124
Q	0.115	0.135		0.135	0.135	0.135	0.135	0.135	0.135
R	0.240	0.260		0.252	0.253	0.254	0.254	0.253	0.254
S	0.115	0.135		0.127	0.127	0.127	0.127	0.128	0.126
T	0.178	0.198		0.188	0.188	0.188	0.188	0.188	0.188
U	2.940	2.980		2.960	2.959	2.958	2.959	2.959	2.959
V	0.230	0.250		0.234	0.234	0.234	0.236	0.236	0.2345
W	0.115	0.135		0.123	0.122	0.122	0.127	0.126	0.126
X	0.307	0.312		0.311	0.311	0.311	0.311	0.311	0.311
Y	0.760	0.765		0.762	0.762	0.762	0.762	0.762	0.762
Z	0.352	0.372		0.360	0.363	0.361	0.360	0.360	0.361
AA	0.470	0.530		0.500	0.500	0.500	0.500	0.500	0.500
AB	0.615	0.635		0.618	0.618	0.617	0.616	0.619	0.620
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063	0.063
AD	0.240	0.260		0.250	0.245	0.245	0.245	0.245	0.243
AE	1.375	1.395		1.388	1.3865	1.3865	1.386	1.3865	1.387
AF	0.115	0.135		0.135	0.135	0.135	0.135	0.135	0.135
AG	0.240	0.280		0.260	0.260	0.260	0.260	0.260	0.260
AH	0.240	0.260		0.249	0.250	0.249	0.253	0.251	0.249
AI	2.000	2.020		2.004	2.004	2.004	2.003	2.004	2.004
AJ	0.023	0.043		0.033	0.033	0.033	0.033	0.033	0.033
Accept/Reject									

Measured by: <i>DP</i>
Date: 10/06/08

Audited by: <i>amp</i>
Date: 10/06/10





Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

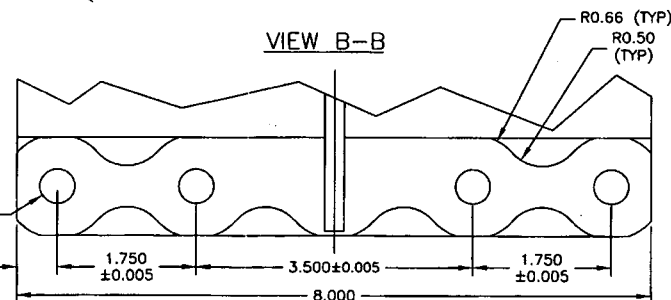
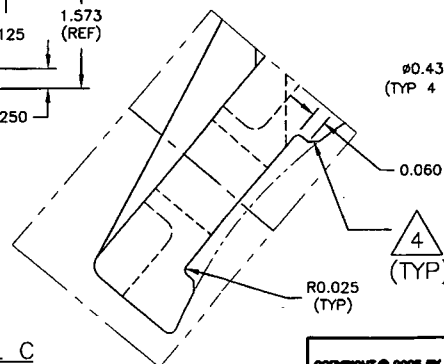
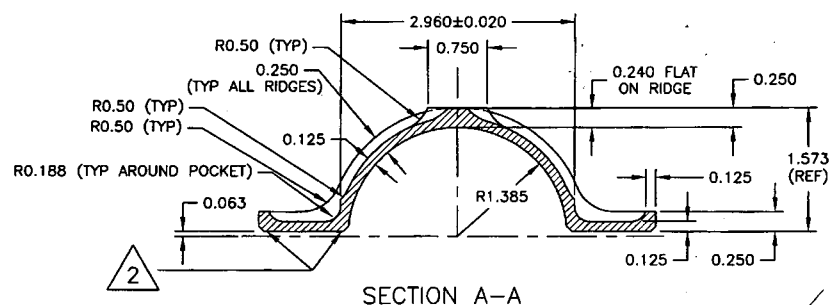
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |






SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AVALANCH
WITHOUT
WORK

NO. 59300

DETAIL C
SCALE 2:1

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
			
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	
CHECKED		APPROVED	
		DRAWING NO.	
		D2572	
		REV. 1 OF	
		SHEET 1 OF	
DATE		TITLE	
05.07.13		INNER FWD SADDLE	
		SCALE	
		2:	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries